



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 180458



Part No: D350-591-311

Job Qty: 10 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/6/18

Job Tracking No:

Due Date: 9/6/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		9/6/18	0.00	0.00	Start Up Large Fab-4		CPC
110	Large Fab	10 pcs		9/6/18	0.00	9.91	Large Fab 2		CPC
120	QC	10 pcs		9/6/18	0.00	0.00	QC9		W
130	QC	10 pcs		9/6/18	0.00	0.00	QC5		W
140	HandFinish	10 pcs		9/6/18	0.00	1.84	HandFinish1		SA 18-08-27
150	QC	10 pcs		9/6/18	0.00	0.00	QC7-2		CPC
180	Large Fab	10 pcs		9/6/18	0.00	9.91	Large Fab 2		CPC
190	QC	10 pcs		9/6/18	0.00	0.00	QC10		W
200	QC	10 pcs		9/6/18	0.00	0.00	QC5		W
210	HandFinish	10 pcs		9/6/18	0.00	1.84	HandFinish1		SA 18-08-29
220	Powdercoat	10 pcs		9/6/18	0.00	2.90	Powdercoat1		BA 18-8-30
230	HandFinish	10 pcs		9/6/18	0.00	1.84	HandFinish3		BA 18-08-30
240	QC	10 pcs		9/6/18	0.00	0.00	QC3		38
250	Packaging	10 pcs		9/6/18	0.00	0.00	Packaging1-3		9-89
260	QC	10 pcs		9/6/18	0.00	0.00	QC4		W
270	Packaging	10 pcs		9/6/18	0.00	0.00	Packaging3-1		W for JB
275	DC	10 pcs		9/6/18	0.00	0.00	DC		W
280	QC21-FG	10 Ea		9/6/18	0.00	0.00	QC21		W 1809.10

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 413875 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 11:45. OVEN TEMPERATURE: 300° FINISH TIME: 12:15.

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

275 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	5091622
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	5091443
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	5104179
D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab	5094055

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D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging
D2618	Bushing	20 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	20 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging

5088668
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Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	133	0
	D3219-1	20	123	0
	D3272-1	10	25	0
180-Large Fab	D3065-041	10	18	0
	D3066-1	20	178	0
	MS20600-AD4W4	160	3,204	0
250-Packaging	AN3-35A	20	380	0
	AN4-13A	80	2,267	0
	AN5-36A	20	324	0
	D2230-3	40	333	0
	D2618	20	220	0
	D2856-400-720	20	74	0
	D3235-1	20	117	0
	D3278-041	10	42	0
	MS21042L3	20	2,128	0
	MS21042L4	80	3,306	0
	MS21042L5	20	922	0
	NAS1149D0363J	40	1,662	0
	NAS1149D0463J	160	7,409	0
	NAS1149D0563J	40	1,662	0

Part Specifications

Specifications could not be found.

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Container No: S104713



Part: D350-591-311

Job No: 180458

Serial No/Batch: S104713

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 11 Date: 11/23/11 FAA STC SH967NE 04/12/21, BRAZIL 1

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

D350-591-311

S104713

REV. B



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

Material Trace Report

Container No	Part No	Operation	Quantity	Weight	Add Date	Location	Status	Update Date	Active
S104713	D350-591-311	QC21-FG	10	0	8/23/18	FG084	Stock	9/10/18	✓
S088668	D3066-1	QC21-SA	0	0	7/3/18	Large Fab 2	Allocated	8/28/18	
S089615	D3235-1	QC21-SA	0	0	7/6/18	Packaging1-3	Allocated	9/10/18	
S091622	D3067-1	QC21-SA	0	0	7/13/18	Start Up Large Fab-4	Allocated	8/23/18	
S094055	D3065-041	QC21-SA	0	0	7/19/18	Large Fab 2	Allocated	8/28/18	
S095168	D3065-041	QC21-SA	0	0	7/23/18	Large Fab 2	Allocated	8/28/18	
S099054	NAS1149D0563J	Receive Ea	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S099108	NAS1149D0463J	Receive Ea	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S099149	NAS1149D0363J	Receive Ea	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S099152	MS21042L5	Receive Ea	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S099162	MS21042L4	Receive Ea	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S099188	MS21042L3	Receive Ea	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S099200	AN5-36A	Receive Ea	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S099221	AN4-13A	Receive Ea	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S099247	D2618	QC21-SA	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S099248	D2856-400-720	QC21-SA	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S104179	D3272-1	QC21-SA	0	0	8/22/18	Start Up Large Fab-4	Allocated	8/23/18	
S104710	D3219-1	QC21-SA	0	0	8/23/18	Start Up Large Fab-4	Allocated	8/23/18	
S105676	D3065-041	QC21-SA	0	0	8/28/18	Large Fab 2	Allocated	8/28/18	
S105677	D3066-1	QC21-SA	0	0	8/28/18	Large Fab 2	Allocated	8/28/18	
S105678	MS20600-AD4W4	Receive Ea	0	0	8/28/18	Large Fab 2	Allocated	8/28/18	
S106503	D3278-041	QC21-SA	0	0	8/29/18	Packaging1-3	Allocated	9/10/18	
S108230	D2230-3	QC21-SA	0	0	9/5/18	Packaging1-3	Allocated	9/10/18	
S108959	AN3-35A	Receive Ea	0	0	9/10/18	Packaging1-3	Allocated	9/10/18	
23 Containers			.00	.00					
23 Containers Total			.00	.00					

Change Record

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Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

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